

Work Order ID 65190

Friday, January 07, 2011 10:40:13 AM



Page 1

Item ID: D3508-11

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 1/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:



Date: 1/10/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3508	Rev C

100



FLOW WATER JET

0.00

Waterjet

Memo

0.00

FLOW CNC Waterjet

304 . 040

1-Cut as per Dwg D3508

 Dwg Rev: C Prog Rev: C 2-

Deburr if necessary

B11-1-10

(6)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

B11-1-10

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

Sulawico

x6

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

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Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130

Operation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Form on brake using DT8326 and DT8261 as per Dwg D3508

SB 11/01/11

(6)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/16/11

(XG)

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M 112588

10:25

OVEN TEMPERATURE:
10:55

Memo

START TIME:
320FINISH TIME:
320

6 8/11-01-11

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Page 3

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Setup

Start



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Item Name: Wearplate

Stop



Start Date: 1/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID**

160



QC

Quality Control

**Operation
Description**

QC3- Inspect Part Finish

**Set Up/
Run Hours**

0.00

Tool ID

Tool #

**Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

170



Packaging

Packaging

Identify as per dwg & Stock Location: F12-16

0.00

0.00

X6 Q M W0114

MF 11-01-12

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

110112 J

MF
11-01-12

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Picklist Print

Friday, January 07, 2011 10:40:17 AM

Page 1

Work Order ID: 65190



Parent Item: D3508-11



Parent Item Name: Wearplate

Start Date: 1/7/2011

Required Date: 1/14/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07.06.12 EC
IPP Rev:B Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	181.0714	0.5887	3.718105		 181-1-10	

304/316 .040 Sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	178.3	
	10.2	
	11.1	
	157	116437
MAT20	2.7714	
	1.398	
	1.3734	

(6)

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DART AEROSPACE LTD	Work Order:	65190
Description: Wearplate	Part Number:	D3508-11
Inspection Dwg: D3508 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	11-1-10	Date:	11/01/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD	 

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NOTE: Date & initial all entries

8

7

6

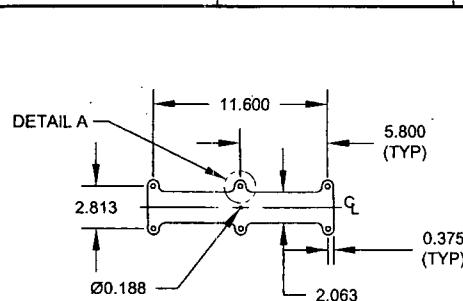
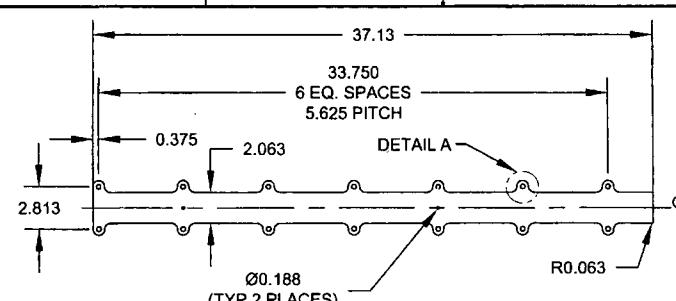
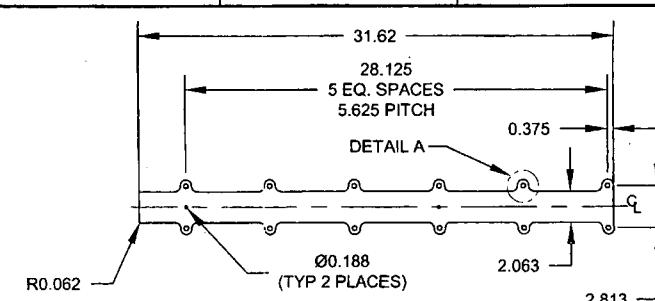
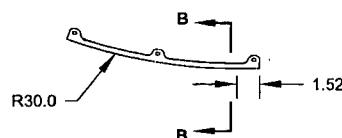
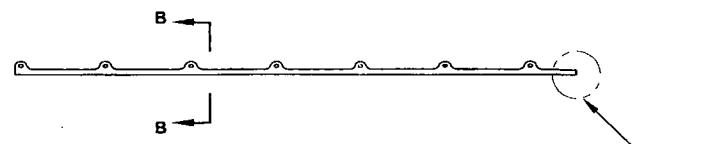
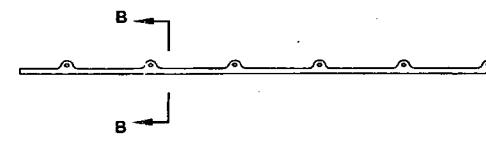
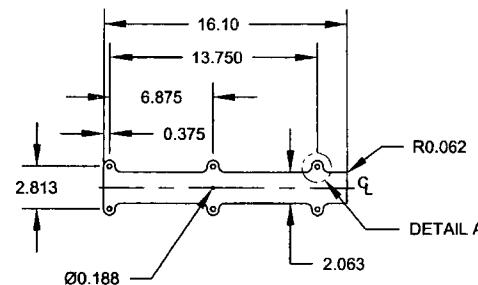
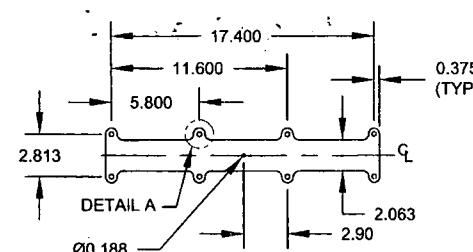
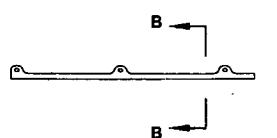
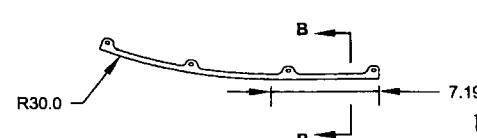
5

4

3

2

1

**D3508-1 FLAT PATTERN****D3508-3 FLAT PATTERN****D3508-5 FLAT PATTERN****D3508-1 BENDING DETAIL**
(MAKE FROM D3508-1F)**D3508-3 BENDING DETAIL**
(MAKE FROM D3508-3F)**D3508-5 BENDING DETAIL**
(MAKE FROM D3508-5F)**D3508-7F FLAT PATTERN****D3508-9F FLAT PATTERN****D3508-7F BENDING DETAIL**
(MAKE FROM D3508-7F)**D3508-9F BENDING DETAIL**
(MAKE FROM D3508-9F)**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs
D3508-13 - 0.25 lbs

RELEASED
07-11-16

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 63190

PL 100-017

C	ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION		
DESIGN	<i>✓</i>	DART AEROSPACE USA, INC	
DRAWN	<i>✓</i>	PORT HADLOCK, WA	
CHECKED	<i>✓</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>✓</i>	D3508	SHEET 1 OF 2
APPROVED	<i>✓</i>	TITLE	SCALE
DE APPR.	<i>✓</i>	WEARPLATE	1:8
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE USA, INC. AND IS PROVIDED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

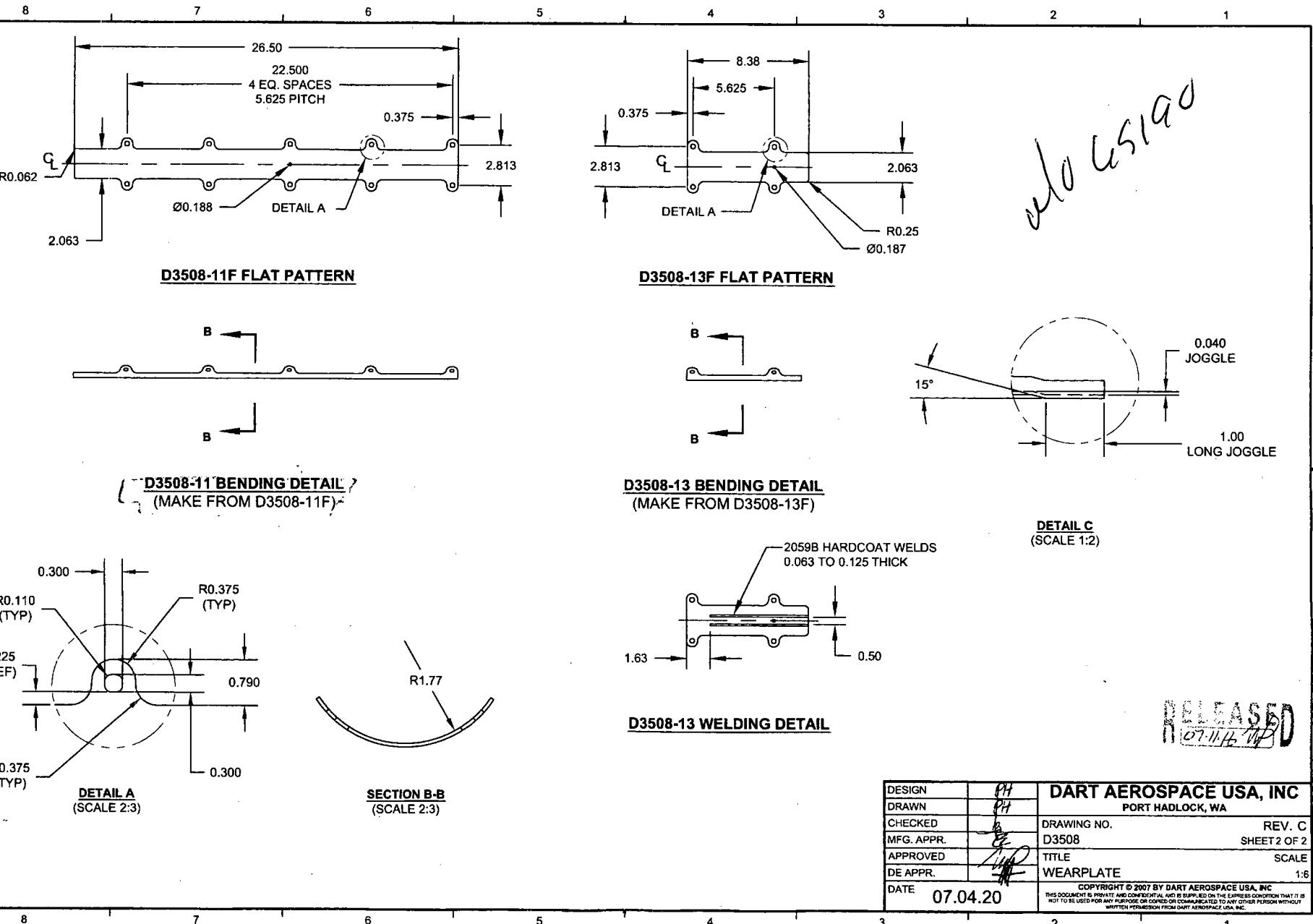
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